

Work Order ID 76805

76805

Page 1

Monday, November 21, 2011 11:24:35 AM

Item ID: D2662-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH In 206
 Start Date: 11/21/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 12/16/2011 Req'd Qty: 10.00 ***10*** Customer:

Reference:

Approvals: Process Plan: *P* Date: 11-21 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev E								

100

0.00

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program part number and batch number.
 Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB068 & DWG

DWG REV: E

FOLIO REV: AA

0.00

B.A 11/12/27

10

0

110

0.00

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Machine Keyway and inspect per attached dimension sheet

0.00

B.A 11/12/27

10

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

10X4 m-2 12/01/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH In 206
 Start Date: 11/21/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 12/16/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150 Powdercoat Powder Coating	Memo START TIME: <u>3:30</u> OVENTEMPERATURE: <u>320°F</u> FINISH TIME: <u>4:00</u>	0.00							10X4 M-L 12/01/05
160	QC3- Inspect Part Finish	0.00							
160 QC Quality Control	Memo	0.00							10 BR 12-1-6.
170	Identify as per dwg & Stock Location: <u>435</u>	0.00							
170 Packaging Packaging	Memo	0.00							10/01/05 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 76805***76805***

Page 4

Monday, November 21, 2011 11:24:35 AM

Item ID: D2662-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH In 206

Start Date: 11/21/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/16/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00


180

QC

Memo

0.00

Quality Control

12/1/9 
CMF
12-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 21, 2011 11:24:39 AM

Page 1

Work Order ID: 76805

76805

Parent Item: D2662-1

D2662-1

Parent Item Name: Saddle, LH In 206

Start Date: 11/21/2011

Required Date: 12/16/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C00.06.22Removed P/O for powder coatEC
IPP Rev:D As per Rev D 07-03-19 JLM IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001		Manufactured	No			100	Each	152.0000	1	10			
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D6101-001

Saddle Billet

**

11-12-24

Location	Loc Qty	Loc Code
MAT040	152	
66965	1	
69677	2	
73774	60	
74648	21	
74679	68	

76836

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	76805
Description: 206 Saddle, Inboard, Left side	Part Number:	D2662-1
Inspection Dwg: D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions				5 By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.136	0.137	0.137	0.137	0.136	
B	0.100	0.140		0.136	0.126	0.126	0.125	0.125	
C	1.125	1.145		1.137	1.137	1.136	1.137	1.137	
D	0.615	0.685		0.685	0.685	0.685	0.685	0.685	
E	0.240	0.260		0.249	0.249	0.249	0.249	0.249	
F	1.313	1.343		1.323	1.323	1.323	1.323	1.323	
G	0.210	0.230		0.226	0.220	0.226	0.226	0.226	
H	0.100	0.180		0.135	0.135	0.135	0.135	0.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.582	1.577	1.576	1.577	1.577	
K	0.235	0.240		0.237	0.237	0.237	0.237	0.237	
L	0.100	0.120		0.110	0.110	0.110	0.110	0.110	
M	0.990	1.010		0.999	0.999	0.999	0.999	0.999	
N	0.510	0.515		0.512	0.512	0.512	0.512	0.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		0.314	0.314	0.314	0.314	0.314	
S	0.315	0.322		0.316	0.316	0.316	0.316	0.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		0.796	0.796	0.796	0.796	0.796	
W	0.540	0.560		0.550	0.550	0.550	0.550	0.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		0.260	0.260	0.260	0.260	0.260	
Z	0.912	0.932		0.922	0.922	0.922	0.923	0.923	
AA	0.490	0.510		0.500	0.501	0.498	0.501	0.501	
AB	0.178	0.198		0.188	0.188	0.188	0.188	0.188	
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: A.A	Audited by: S
Date: 11/12/27	Date: 12-01-03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76805
Description: 206 Saddle, Inboard, Left side		Part Number: D2662-1
Inspection Dwg: D2662 Rev. D		Page 1 of 1

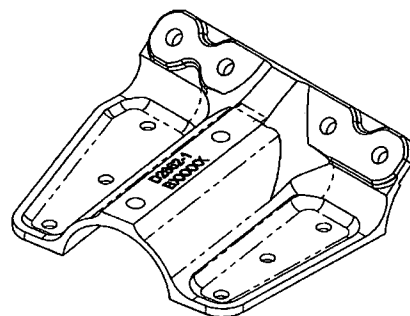
Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					Date
				16	17	18	19	10 By	
A	0.100	0.140		0.137	0.137	0.137	0.136	0.136	
B	0.100	0.140		0.126	0.126	0.126	0.126	0.125	
C	1.125	1.145		1.137	1.137	1.137	1.137	1.137	
D	0.615	0.685		0.685	0.685	0.685	0.685	0.685	
E	0.240	0.260		0.248	0.249	0.249	0.248	0.249	
F	1.313	1.343		1.323	1.323	1.323	1.323	1.323	
G	0.210	0.230		0.220	0.219	0.220	0.220	0.220	
H	0.100	0.180		0.135	0.135	0.135	0.135	0.135	
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	
J	1.565	1.585		1.577	1.577	1.577	1.577	1.577	
K	0.235	0.240		0.237	0.237	0.237	0.237	0.237	
L	0.100	0.120		0.110	0.110	0.110	0.110	0.110	
M	0.990	1.010		0.999	0.999	0.999	0.999	0.999	
N	0.510	0.515		0.512	0.512	0.512	0.512	0.512	
O	5.990	6.010		6.000	6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
R	0.313	0.318		0.314	0.314	0.314	0.314	0.314	
S	0.315	0.322		0.316	0.316	0.316	0.316	0.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	
V	0.787	0.807		0.797	0.797	0.797	0.797	0.796	
W	0.540	0.560		0.550	0.550	0.550	0.550	0.550	
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	
Y	0.257	0.262		0.260	0.260	0.260	0.260	0.260	
Z	0.912	0.932		0.922	0.922	0.922	0.922	0.923	
AA	0.490	0.510		0.500	0.501	0.500	0.501	0.500	
AB	0.178	0.198		0.188	0.188	0.188	0.188	0.188	
AC									
AD									
AE									
AF									
Accept/Reject									

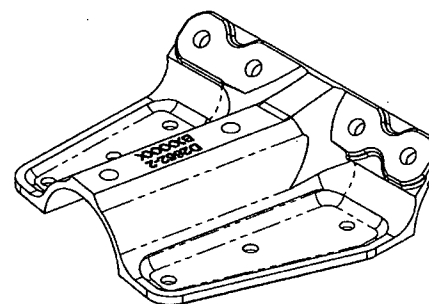
Measured by: B.A.
Date: 11/12/27

Audited by: [Signature]
Date: 12-01-03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM [Signature]	[Signature]



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

SEE
RETURN
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO
WORK CENTER
NO. 76805

21-11-21

RELEASED
2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4). REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP' DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2662 TITLE SADDLE, INSIDE SCALE NTS SHEET 1 OF 5 REV. E DATE 11.10.31	
DRAWN	<i>JP</i>		
CHECKED	<i>ASS</i>		
MFG. APPR.	<i>JP</i>		
DE APPR.	<i>JP</i>		
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

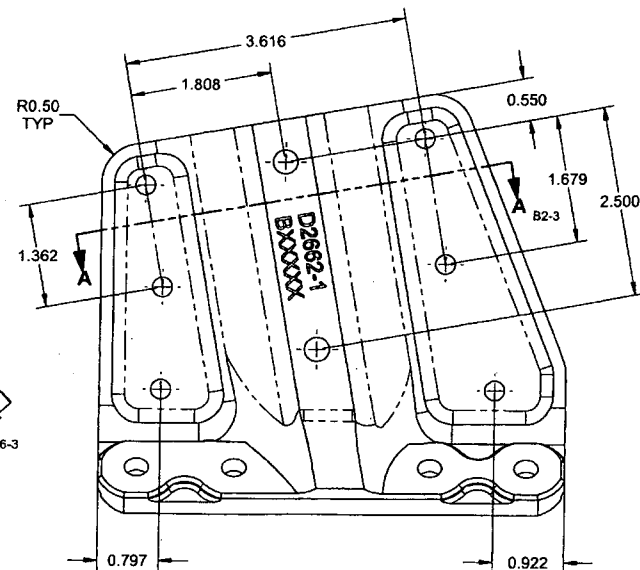
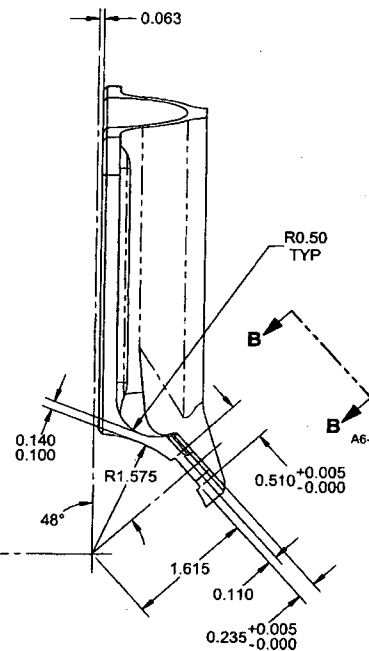
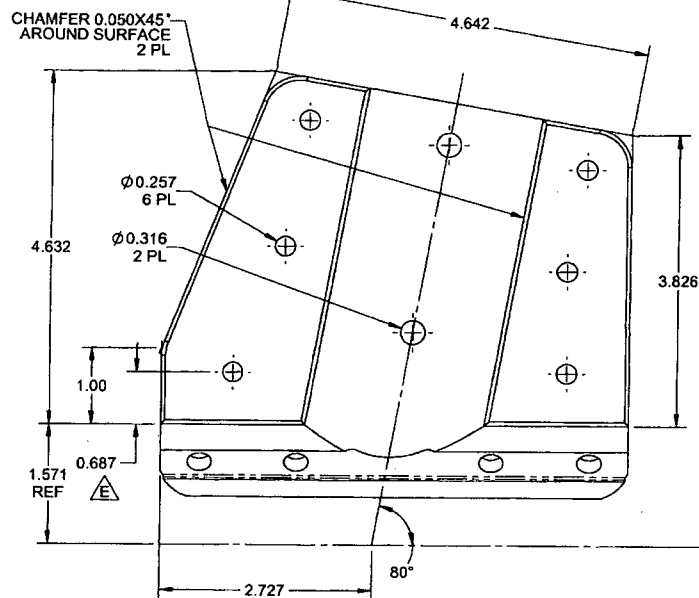
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2662-1 SADDLE, INSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

RELEASE
2011-11-16

76805

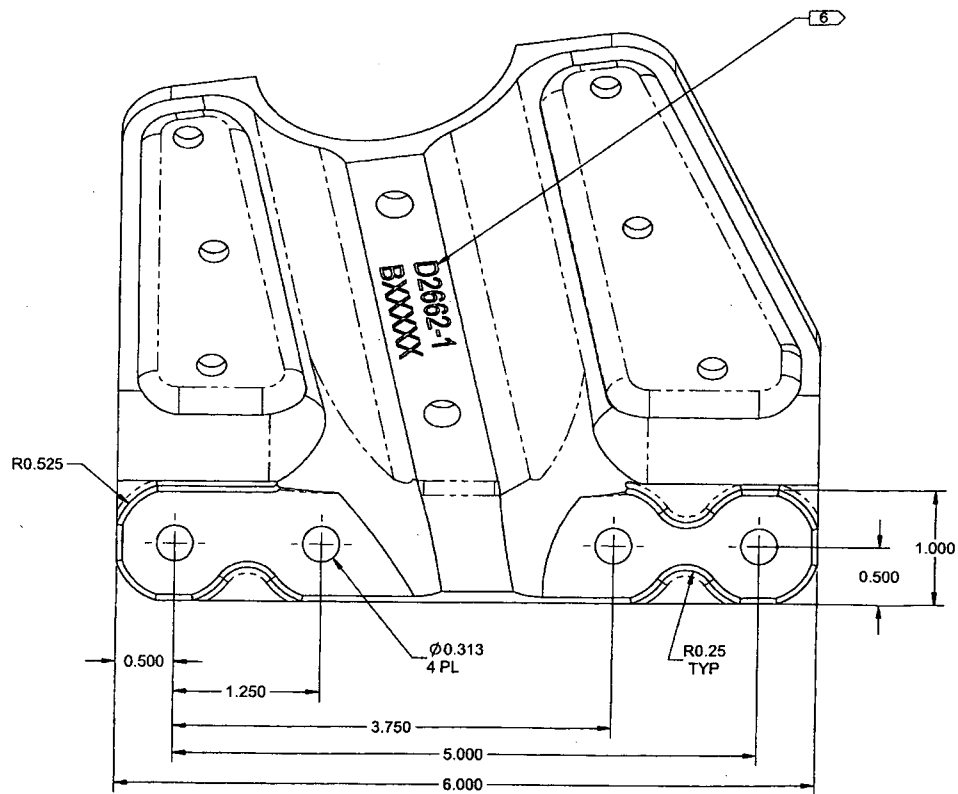
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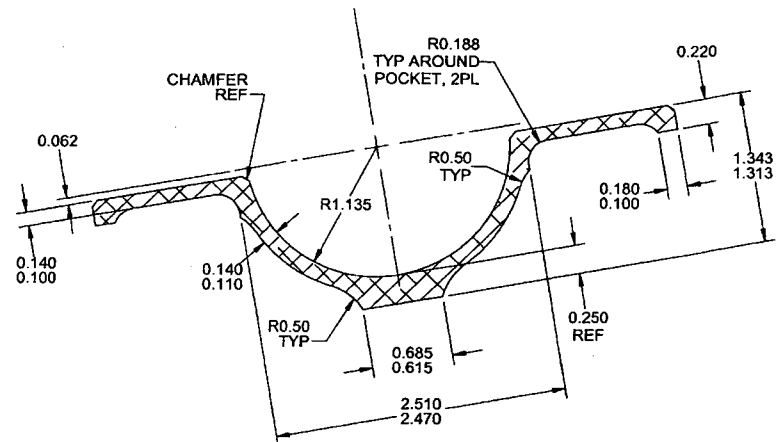
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NOTE: Date & initial all entries



VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED



VIEW A-A C1-2
SCALE 1.5X

RELEASED
2011-11-16

76805

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	90	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	IMP	D2662	SHEET 3 OF 5
APPROVED	IMP	TITLE	SCALE
DE APPR.	IMP	SADDLE, INSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

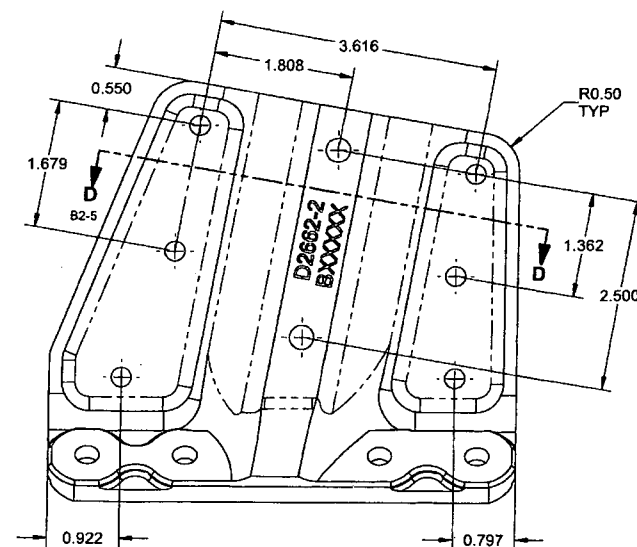
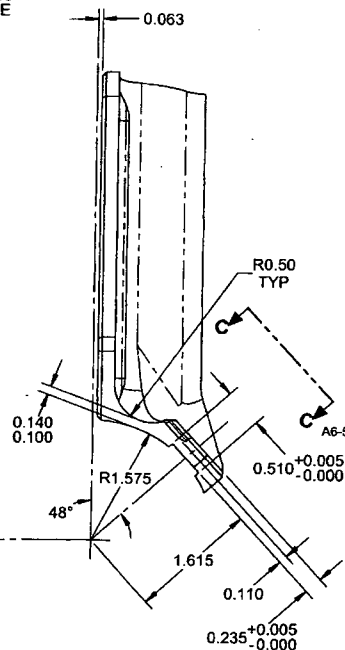
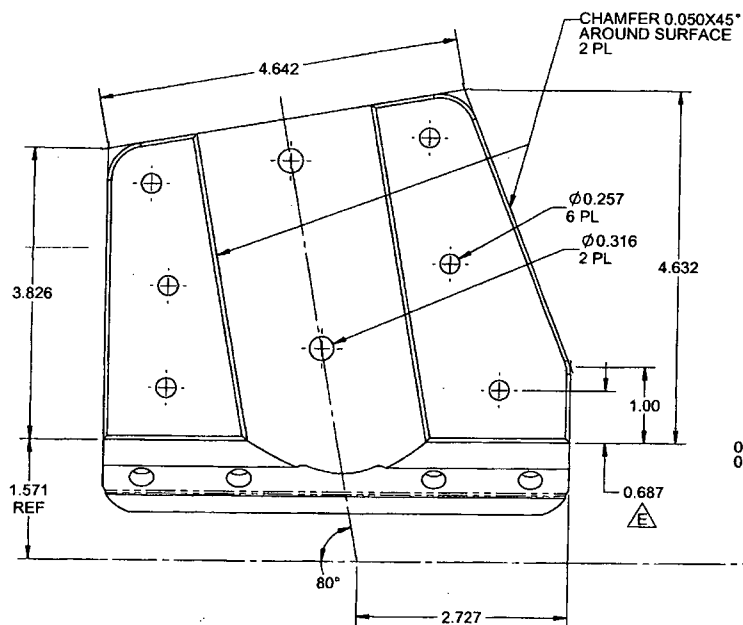
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2662-2 SADDLE, INSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209 MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING) USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN	<i>JS</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>JS</i>	KENT, WA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>JS</i>	D2662	SHEET 4 OF 5
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	SADDLE, INSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC.	
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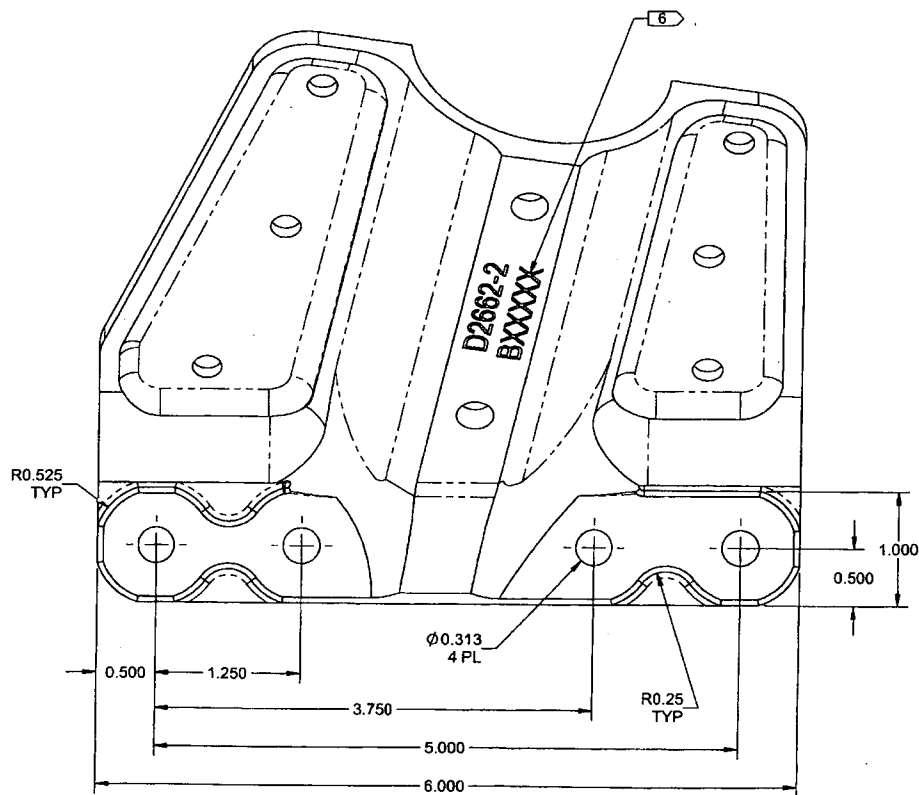
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

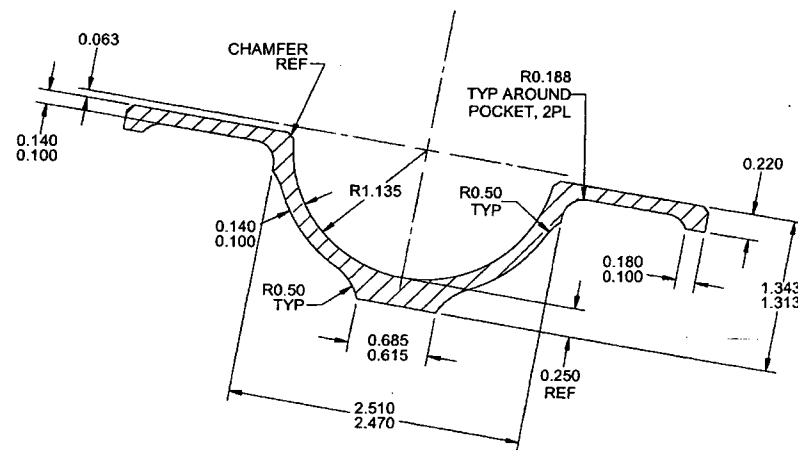
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



VIEW C-C C3-4
SCALE 1.5X

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries